



(19)

Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 1 160 353 A1

(12)

## EUROPEAN PATENT APPLICATION

(43) Date of publication:  
05.12.2001 Bulletin 2001/49(51) Int Cl.7: C23C 16/36, C23C 30/00,  
C23C 16/02

(21) Application number: 00111028.7

(22) Date of filing: 31.05.2000

(84) Designated Contracting States:  
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU  
MC NL PT SE  
Designated Extension States:  
AL LT LV MK RO SI

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(54) Coated cemented carbide cutting tool member and process for producing the same

(57) A coated cemented carbide cutting tool member and a process for production thereof are disclosed. The coated cemented carbide cutting tool comprises a substrate and a hard coating layer deposited on said substrate by chemical vapor deposition and/or physical vapor deposition, wherein said hard coating layer has average thickness of 3 to 25 µm, and comprises (1) at least one Ti compounds layer that is composed of at

least one granular layer of TiC, TiN, TiCN,  $Ti_2O_3$ ,  $TiCO$ ,  $TiNO$  and  $TiCNO$ , whose average thickness is 0.1 to 5 µm, (2) TiCN layer having longitudinal growth crystal structure whose average thickness is 2 to 15 µm, and (3)  $Al_2O_3$  layer whose average thickness is 0.5 to 8 µm, wherein, said longitudinal TiCN layer has compositional gradient of carbon and nitrogen along with its growth direction.

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**Description****BACKGROUND OF THE INVENTION**5   **Field of the invention**

[0001] The present invention relates to a coated cemented carbide cutting tool member (hereinafter referred as "coated carbide member") that resists breakage and chipping of its cutting edge for a long period of time, particularly when it is applied to cutting operations of extremely severe conditions such as high speed, high feed, thick depth-of-cut interrupted cutting of steels and cast irons because its hard coating layer includes improved titanium carbonitride layer having longitudinal crystal structure that has superior characteristics against chipping at cutting edge.

**Description of the Related Art**

15   [0002] It is well known that coated carbide member is manufactured by depositing a hard coating layer, having an average thickness of 3 to 25  $\mu\text{m}$  preferably comprise (a) at least one titanium compound layer having an average thickness of 0.1 to 5  $\mu\text{m}$  and composed of at least one layer of granular titanium compound selected from titanium carbide (hereinafter referred to as "TiC"), titanium nitride (TiN), titanium carbonitride (TiCN), titanium oxide ( $\text{Ti}_2\text{O}_3$ ), titanium carboxide (TiCO), titanium nitroxide (TiNO) and titanium carbonitroxide (TiCNO), (b) TiCN layer having longitudinal growth crystal structure (1-TiCN) with its average thickness of 2 to 15  $\mu\text{m}$ , and (c) aluminum oxide ( $\text{Al}_2\text{O}_3$ ) layer having an average thickness of 0.5 to 8  $\mu\text{m}$ , on tungsten carbide-based cemented carbide substrate. The common technique for depositing said hard coating layer is CVD (Chemical Vapor Deposition) and/or PVD (Physical Vapor Deposition). It is also widely known that coated carbide member is widely used in various fields of cutting operations, for example, continuous and interrupted cutting operation of metal work pieces such as steels and cast irons.

20   [0003]  $\text{Al}_2\text{O}_3$  layer have several different crystal polymorphs, among which the alpha- $\text{Al}_2\text{O}_3$  is known as thermodynamically the most stable polymorph having corundum structure, and typical polymorphs of  $\text{Al}_2\text{O}_3$  layer used as hard coating layer are stable alpha- $\text{Al}_2\text{O}_3$  and meta-stable kappa- $\text{Al}_2\text{O}_3$ . 1-TiCN layer is manufactured by CVD method at moderate temperature range such as 700 to 950°C using reaction gas mixture which includes organic cyanide compounds such as acetonitrile ( $\text{CH}_3\text{CN}$ ), that was disclosed in Japanese Unexamined Patent Publication No.6-8010 and No.7-328808.

25   [0004] In recent years, there has been an increasing demand for laborsaving, less time consuming cutting operations. Accordingly, there is a tendency that the condition of cutting operation has changed to severe side, such as high speed, high feed and thick depth-of-cut. With regard to conventional coated carbide member, 1-TiCN layer that is constituent of conventional hard coating layer has fairly good toughness itself, consequently whole hard coating layer also shows sufficient toughness. So, it exhibits excellent cutting performance without any chipping at cutting edge when it is applied to high speed continuous cutting operations. Meanwhile, when it is applied to extremely severe cutting condition such as high speed, high feed and thick depth-of-cut interrupted cutting operations, chipping at cutting edge is by all means inevitable because of its insufficient toughness for these cutting operations, consequently the tool lifetime become shorter.

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**SUMMARY OF THE INVENTION**

[0005] Accordingly, one object of the present invention is to provide a coated carbide member that resists chipping of cutting edge over long periods of time even when it is applied to high speed, high feed, and thick depth-of-cut interrupted cutting operations of steels and cast irons.

45   [0006] Briefly, this object of the present invention as hereinafter will become more readily apparent can be attained by a coated carbide member for a cutting tool comprising a substrate and a hard coating layer on said substrate, wherein the hard coating layer comprises (a) at least one titanium compound layer composed of at least one layer of granular titanium compound selected from TiC, TiN, TiCN,  $\text{Ti}_2\text{O}_3$ , TiCO, TiNO and TiCNO, (b) 1-TiCN layer 50   having a compositional gradient of carbon (C) and nitrogen (N) along with its growth direction (gradient 1-TiCN), and (c)  $\text{Al}_2\text{O}_3$  layer,

55   wherein gradient 1-TiCN is expressed by molecular formula  $\text{TiC}_{1-x}\text{N}_x$ , wherein x is the atomic ratio of N to the sum of C and N, and it ranges from 0.45 to 0.95 at top portion of said gradient 1-TiCN layer and ranges from 0.05 to 0.40 at bottom portion of that.

[0007] A further object of the present invention is to provide a process for producing a coated carbide member with gradient 1-TiCN layer by changing the gas concentration of the reactive gas concentration of  $\text{CH}_3\text{CN}$ ,  $\text{CH}_4$ , and/or  $\text{N}_2$ , and the deposition temperature, from 850-950°C for the bottom portion to 960-1040°C for the top portion, during the deposition period of 1-TiCN layer.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0008] The present invention provides a hard coating layer that is coated on the cutting member of a cutting tool. The term "cutting member" refers to the part of the cutting tool that actually cuts the work piece. Cutting members include exchangeable cutting inserts which are mounted on the bit holders of turning tools, face milling cutter bodies, and end-milling cutter bodies. Cutting members also include the cutting blade of drills and end-mills. The cutting member is preferably made of tungsten carbide-based cemented carbide substrates.

[0009] The hard coating layer preferably coats a portion of the surface, more preferably the entire surface of the cutting member. The hard coating layer is preferably comprise (a) at least one titanium compound layer composed of at least one layer of granular titanium compound selected from TiC, TiN, TiCN,  $Ti_2O_3$ , TiCO, TiNO and TiCNO, (b) 1-TiCN layer having a compositional gradient of C and N along with its growth direction, and expressed as  $TiC1-xNx$ , wherein x ranges from 0.45 to 0.95 at top portion, and it ranges from 0.05 to 0.40 at bottom portion, and (c)  $Al_2O_3$  layer.

[0010] The preferred embodiments of the present invention were discovered after testing many different kinds of hard coating layers on cemented carbide cutting member from the standpoint of developing a new long lifetime coated carbide member whose hard coating layer has further improved toughness characteristics. From these tests, the following result (A) and (B) were found:

(A) Continuous or periodical changes of the gas concentration of the reactive gas component such as  $CH_3CN$ ,  $CH_4$  and/or  $N_2$  during the deposition period of 1-TiCN layer gives 1-TiCN layer that has a compositional gradient of C and N along with its growth direction, the concentration of C decreased and that of N increased from bottom to top in that layer. This gradient 1-TiCN layer is expressed by molecular formula  $TiC1 -xNx$ , wherein x is the atomic ratio of N to the sum of C and N, and it ranges from 0.45 to 0.95 at top portion of said gradient 1-TiCN layer and ranges from 0.05 to 0.40 at bottom portion of it. In this case, the concentration gradient from bottom portion to top portion is varies, continuously or step by step, owing to its manufacturing gas condition.

Further, a manufacturing process in which the deposition temperature is changed from 850-950°C for the bottom portion to 960-1040°C for the top portion together with the change in gas concentration mentioned above gives a more favorable crystal structure of said gradient 1-TiCN layer.

(B) Said gradient 1-TiCN layer has excellent toughness compared to conventional 1-TiCN layer manufactured by CVD method at moderate temperature range such as 700 to 950°C without any compositional gradient in it. Therefore with regard to coated carbide member that include said gradient 1-TiCN layer as a constituent of hard coating layer, the hard coating layer itself become all the tougher by the effect of said tough gradient 1-TiCN layer, it gives fairly long tool lifetimes without any chipping at cutting edge even when it is applied to extremely severe cutting operations such as high speed, high feed, and thick depth-of-cut interrupted cutting of steels and cast irons.

[0011] Based on these results, the present invention provides for a coated carbide member that exhibits superior resistance against chipping at cutting edge for a long period of time even when it is applied to extremely severe cutting operations such as high speed, high feed, and thick depth-of-cut interrupted cutting of steels and cast irons, because of excellent toughness of the hard coating layer, by providing a coated carbide member preferably composed of a cemented carbide substrate and a hard coating layer preferably having an average thickness of 3 to 25  $\mu m$  formed on the substrate by means of CVD and/or PVD method, and that comprise (a) at least one titanium compound layer having average thickness of 0.1 to 5  $\mu m$  and composed of at least one layer of granular titanium compound selected from TiC, TiN, TiCN,  $Ti_2O_3$ , TiCO, TiNO and TiCNO, (b) 1-TiCN layer that has compositional gradient of C and N along with its growth direction having average thickness of 2 to 15  $\mu m$  and expressed by molecular formula  $TiC1-xNx$ , wherein x is the atomic ratio of N to the sum of C and N, and it ranges from 0.45 to 0.95 at top portion and ranges from 0.05 to 0.40 at bottom portion, and (c)  $Al_2O_3$  layer having average thickness of 0.5 to 8  $\mu m$ .

[0012] In the present invention, the average thickness of the hard coating layer is preferably 3 to 25  $\mu m$ . Excellent wear resistance cannot be achieved at a thickness of less than 3  $\mu m$ , whereas breakage and chipping at the cutting edge of the cutting member easily occur at a thickness of over 25  $\mu m$ .

[0013] Individual Ti compound layers have a function to ensure sufficient adherence between different two layers. It becomes difficult to keep sufficient adherence at a thickness of less than 0.1  $\mu m$ , whereas wear resistance decreases at a thickness of over 5  $\mu m$ . So, the average thickness of individual Ti compound layers is set to 0.1 to 5  $\mu m$ .

[0014]  $Al_2O_3$  layer has a function to increase wear resistance of hard coating layer especially for high speed cutting operation because of its satisfactory properties such as thermal barrier and oxidation resistance. It becomes difficult to achieve enough wear resistance at a thickness of less than 0.5  $\mu m$ , whereas chipping at cutting edge easily becomes to occur at a thickness of over 8  $\mu m$ . So, the average thickness of  $Al_2O_3$  layer is set to 0.5 to 8  $\mu m$ .

[0015] Gradient 1-TiCN layer has a function to improve the toughness of hard coating layer as noted above. It becomes difficult to provide satisfactory properties of this layer at a thickness of less than 2  $\mu m$ , whereas wear resistance of this layer decrease sharply at a thickness of over 15  $\mu m$ . So, the average thickness of gradient 1-TiCN layer is set

to 2 to 15  $\mu\text{m}$ .

[0016] With regard to gradient 1-TiCN layer expressed as  $\text{TiC}_{1-x}\text{N}_x$ , when  $x$  value at top portion is less than 0.45 or that value at bottom portion is more than 0.40, the concentration gradient of C and N becomes rather small, consequently the sufficient improvement of layer toughness cannot be attained. Meanwhile, when  $x$  value at top portion is more than 0.95 or that value at bottom portion is less than 0.05, it becomes difficult to secure its longitudinal crystal structure, consequently the toughness of said layer decreases sharply, then chipping at cutting edge easily occur. So, the  $x$  value at top portion is set to 0.45 to 0.95, preferably to 0.50 to 0.75, and the  $x$  value at bottom portion is set to 0.05 to 0.40, preferably to 0.15 to 0.35.

[0017] Having generally described this invention, a further understanding can be obtained by reference to certain specific Examples that are provided herein for purposes of illustration only and are not intended to be limiting unless otherwise specified.

### EXAMPLES

#### Example 1

[0018] The following powdered materials were prepared as raw materials for substrates: a WC powder with an average grain size of 1.5  $\mu\text{m}$  or 3.0  $\mu\text{m}$ , a (Ti,W)CN powder ( $\text{TiC}/\text{TiN}/\text{WC}=24/20/56$ ) with an average grain size of 1.2  $\mu\text{m}$ , a TaC/NbC powder ( $\text{TaC}/\text{NbC}=90/10$ ) with an average grain size of 1.3  $\mu\text{m}$ , a  $\text{Cr}_3\text{C}_2$  powder with an average grain size of 1  $\mu\text{m}$ , a VC powder with an average grain size of 1.2  $\mu\text{m}$  and Co powder with an average grain size of 1.2  $\mu\text{m}$ . Those powders were compounded based on the formulation shown in Table 1, wet-mixed in a ball mill for 72 hours and dried. Several dry powder mixtures were prepared in this manner and then each was pressed at a pressure of 1 ton/cm<sup>2</sup> to form green compacts, which were sintered under the following conditions; pressure: 0.001Torr, temperature: 1400 to 1460°C, holding duration: 1 hour, to manufacture cemented carbide insert substrates A through E defined in ISO-CNMG120408.

[0019] The cutting edges of the cemented carbide insert substrates A through F were honed. Each substrate was subjected to chemical vapor deposition using conventional equipment under the conditions shown in Tables 2 and 3 to provide hard coating layers on the substrate. Individual coating layers shown in Table 2 has homogeneous composition from bottom to top of that layer, and every coating layers other than 1-TiCN in Table 2 has granular crystal structure. To manufacture coated cemented carbide inserts in accordance with the present invention and conventional, a hard coating layer was coated on each substrate, wherein the designed coating layer structure and thickness of each layer is shown in Tables 4, 5. Coated cemented carbide inserts in accordance with the present invention 1 through 10 and conventional coated carbide inserts 1 through 10 were manufactured in such a manner.

[0020] In Table 4, the description for example this invention 1 "1-TiCN (a) ~ 1-TiCN (2) [5 steps], (4.3)" means a gradient 1-TiCN layer of 4.3  $\mu\text{m}$  of its aimed thickness which has prepared by following method, that is, bottom portion of said layer was manufactured using gas condition of 1-TiCN (a) in Table 3, top portion of said layer was manufactured using gas condition of 1-TiCN (2), and there were 5 steps of change in gas concentration of  $\text{CH}_3\text{CN}$ ,  $\text{CH}_4$  and/or  $\text{N}_2$  during deposition of said layer. Likewise, the description for example this invention 2 "1-TiCN (b) ~ 1-TiCN (1) [continuous], (3.8)" means a gradient 1-TiCN layer of 3.8  $\mu\text{m}$  of its aimed thickness which has prepared by following method, that is, bottom portion of said layer was manufactured using gas condition of 1-TiCN (b) in Table 3, top portion of said layer was manufactured using gas condition of 1-TiCN (1), and there was a continuous change in gas concentration of  $\text{CH}_3\text{CN}$ , and/or  $\text{N}_2$  during deposition of said layer.

[0021] To investigate the  $x$  value at the portion both 0.2  $\mu\text{m}$  from upper interface and 0.2  $\mu\text{m}$  from lower surface of individual gradual 1-TiCN layer for coated cemented carbide in accordance with present invention 1 through 10, a cross-sectional analysis using Auger Electron Spectroscopy (AES) was performed and it was confirmed that  $x$  value of individual gradient 1-TiCN layer was almost identical to the designed value. From the investigation of the hard coating layers using optical microscope, the thickness of each layer was almost identical to designed thickness.

[0022] Further, for coated cemented carbide inserts of the present invention 1 through 10 and conventional coated cemented carbide inserts 1 through 10, the following interrupted cutting tests were conducted. The wear width on the flank face was measured in each test. The results are shown in Table 6.

(1-1) Cutting style: Interrupted turning of alloyed steel

#### [0023]

Work piece: JIS SCM440 round bar having 4 longitudinally grooves

Cutting speed: 300 m/min

Feed rate: 0.32 mm/rev

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Depth of cut: 5 mm  
Cutting time: 10 min  
Coolant: Dry

5 (1-2) Cutting style: Interrupted turning of alloyed steel

[0024]

Work piece: JIS SCM440 round bar having 4 longitudinally grooves

10 Cutting speed: 300 m/min  
Feed rate: 0.6 mm/rev  
Depth of cut: 1.5 mm  
Cutting time: 10 min  
Coolant: Dry

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Table 1

Carbide substrate	Composition (wt%)					
	Co	(Ti,W)CN	(Ta,Nb)C	Cr <sub>3</sub> C <sub>2</sub>	VC	WC
A	6	-	2	-	-	Balance (1.5 $\mu$ m)
B	6	6	-	0.1	0.2	Balance (3.0 $\mu$ m)
C	7	7	5	0.4	-	Balance (3.0 $\mu$ m)
D	8	5	4	0.4	0.2	Balance (3.0 $\mu$ m)
E	10	-	-	0.1	-	Balance (1.5 $\mu$ m)

WC:average grain size 1.5  $\mu$  m or 3.0  $\mu$  m

Table 2  
Manufacturing conditions of hard coating layer

Hard coating layer	Composition of reactive gas (volume %)	Manufacturing conditions of hard coating layer	
		Pressure (Torr)	Ambience Temperature (°C)
TiC	TiCl <sub>4</sub> : 3%, CH <sub>4</sub> : 4%, H <sub>2</sub> : Balance	50	1020
TiN (1st layer)	TiCl <sub>4</sub> : 3%, N <sub>2</sub> : 40%, H <sub>2</sub> : Balance	150	900
TiN (others)	TiCl <sub>4</sub> : 3%, N <sub>2</sub> : 45%, H <sub>2</sub> : Balance	50	1040
TiCN	TiCl <sub>4</sub> : 3%, N <sub>2</sub> : 30%, CH <sub>3</sub> CN : 1%, H <sub>2</sub> : Balance	50	900
TiCN	TiCl <sub>4</sub> : 3%, N <sub>2</sub> : 6%, CH <sub>4</sub> : 2%, H <sub>2</sub> : Balance	120	960
Ti <sub>2</sub> O <sub>3</sub>	TiCl <sub>4</sub> : 3%, CO <sub>2</sub> : 2%, H <sub>2</sub> : Balance	100	1020
TiCO	TiCl <sub>4</sub> : 3%, CO : 2%, CH <sub>4</sub> : 2%, H <sub>2</sub> : Balance	100	1000
TiNO	TiCl <sub>4</sub> : 3%, N <sub>2</sub> : 30%, CO : 2%, H <sub>2</sub> : Balance	120	1000
TiCNO	TiCl <sub>4</sub> : 3%, CO : 2%, CH <sub>4</sub> : 2%, N <sub>2</sub> : 30%, H <sub>2</sub> : Balance	120	1000
$\alpha - Al_2O_3$	AlCl <sub>3</sub> : 5%, CO <sub>2</sub> : 8%, HCl : 1.5%, H <sub>2</sub> S : 0.5%, H <sub>2</sub> : Balance	50	1000
$\kappa - Al_2O_3$	AlCl <sub>3</sub> : 5%, CO <sub>2</sub> : 6%, HCl : 1.5%, H <sub>2</sub> S : 0.3%, H <sub>2</sub> : Balance	50	950

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Table 3

I-TiCl <sub>1-x</sub> N <sub>x</sub> layer		Manufacturing conditions of gradient I-TiCN layer		
		Composition of reactive gas (volume %)		pressure(kPa) (temperature(°C))
upper portion	I-TiCN(1) (x : 0.45)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 30%, CH <sub>4</sub> : 1%, CH <sub>3</sub> CN : 0.6%, H <sub>2</sub> : Balance	8.0	980
	I-TiCN (2) (x : 0.55)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 30%, CH <sub>4</sub> : 0.6%, CH <sub>3</sub> CN : 0.4%, H <sub>2</sub> : Balance	8.0	980
	I-TiCN (3) (x : 0.65)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 35%, CH <sub>4</sub> : 0.3%, CH <sub>3</sub> CN : 0.4%, H <sub>2</sub> : Balance	8.0	980
	I-TiCN (4) (x : 0.75)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 35%, CH <sub>4</sub> : 0.1%, CH <sub>3</sub> CN : 0.2%, H <sub>2</sub> : Balance	8.0	980
	I-TiCN (5) (x : 0.85)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 40%, CH <sub>3</sub> CN : 0.2%, H <sub>2</sub> : Balance	8.0	980
	I-TiCN (6) (x : 0.95)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 40%, CH <sub>3</sub> CN : 0.05%, H <sub>2</sub> : Balance	8.0	980
lower portion	I-TiCN (a) (x : 0.05)	TiCl <sub>4</sub> : 2%, CH <sub>4</sub> : 3%, CH <sub>3</sub> CN : 0.2%, H <sub>2</sub> : Balance	8.0	930
	I-TiCN (b) (x : 0.10)	TiCl <sub>4</sub> : 2%, CH <sub>4</sub> : 2%, CH <sub>3</sub> CN : 0.4%, H <sub>2</sub> : Balance	8.0	930
	I-TiCN (d) (x : 0.20)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 5%, CH <sub>4</sub> : 1%, CH <sub>3</sub> CN : 1%, H <sub>2</sub> : Balance	8.0	930
	I-TiCN (f) (x : 0.30)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 5%, CH <sub>3</sub> CN : 1%, H <sub>2</sub> : Balance	8.0	930
	I-TiCN (g) (x : 0.35)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 10%, CH <sub>3</sub> CN : 1%, H <sub>2</sub> : Balance	8.0	930
	I-TiCN (g) (x : 0.40)	TiCl <sub>4</sub> : 2%, N <sub>2</sub> : 10%, CH <sub>3</sub> CN : 0.8%, H <sub>2</sub> : Balance	8.0	930

Table 4

Insert	Substrate	Hard coating layer (Figure in parenthesis means designed thickness : $\mu\text{m}$ )				
		First layer	Second layer	Third layer	Forth layer	Fifth layer
1	A	TiN (0.3)	TiCN (1.5) [5 steps], (4.3)	I-TiCN (0) ~ I-TiCN (2) [5 steps], (4.3)	$\alpha$ - $\text{Al}_2\text{O}_3$ (0.6)	TiN (0.3)
2	B	TiC (0.4)	TiN (0.7)	I-TiCN (b) ~ I-TiCN (1) [continuous], (3.8)	TiCO (0.5)	$\kappa$ - $\text{Al}_2\text{O}_3$ (7.8)
3	B	TiN (0.5)	I-TiCN (c) ~ I-TiCN (5) [3 steps], (4.0)	TiCNO (0.6)	$\alpha$ - $\text{Al}_2\text{O}_3$ (1.8)	TiN (0.4)
4	C	TiC (0.5)	I-TiCN (c) ~ I-TiCN (3) [continuous], (7.2)	TiC (1.5)	$\kappa$ - $\text{Al}_2\text{O}_3$ (3.7)	$\alpha$ - $\text{Al}_2\text{O}_3$ (2.4)
5	C	TiN (0.5)	I-TiCN (d) ~ I-TiCN (4) [15 steps], (9.4)	TiCN (0.6)	TiCN (3.6)	TiN (0.4)
6	D	TiN (0.9)	I-TiCN (d) ~ I-TiCN (3) [12 steps], (8.5)	TiC (0.5)	$\kappa$ - $\text{Al}_2\text{O}_3$ (2.6)	TiN (0.4)
7	D	TiN (0.6)	I-TiCN (e) ~ I-TiCN (2) [continuous], (2.1)	TiC (2.7)	TiCNO (0.5)	$\alpha$ - $\text{Al}_2\text{O}_3$ (1.4)
8	E	I-TiCN (e) ~ I-TiCN (4) [continuous], (6.6)	I-TiCN (c) ~ I-TiCN (4) [continuous], (6.6)	Ti <sub>2</sub> O <sub>3</sub> (0.5)	$\kappa$ - $\text{Al}_2\text{O}_3$ (3.2)	TiN (0.4)
9	E	TiC (1.0)	I-TiCN (f) ~ I-TiCN (5) [10 steps], (12.0)	$\alpha$ - $\text{Al}_2\text{O}_3$ (1.6)	TiCO (0.2)	TiCO (0.2)
10	F	TiC (1.2)	TiCNO (0.7)	I-TiCN (f) ~ I-TiCN (6) [continuous], (14.5)	TiNO (0.5)	$\alpha$ - $\text{Al}_2\text{O}_3$ (3.4)

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Table 5

Insert	Substrate	Hard coating layer (Figure in parenthesis means designed thickness ; $\mu\text{m}$ )					
		First layer	Second layer	Third layer	Forth layer	Fifth layer	Sixth layer
Conventional	1 A	TiN (0.3)	TiCN (1.5)	I-TiCN (4.3)	$\alpha - \text{Al}_2\text{O}_3$ (0.6)	TiN (0.3)	—
	2 B	TiC (0.4)	TiN (0.7)	I-TiCN (3.8)	TiCO (0.5)	$\kappa - \text{Al}_2\text{O}_3$ (7.9)	—
	3 B	TiN (0.5)	I-TiCN (4.0)	TiCNNO (0.6)	$\alpha - \text{Al}_2\text{O}_3$ (1.8)	TiN (0.4)	—
	4 C	TiC (0.5)	I-TiCN (7.2)	TiC (1.5)	$\kappa - \text{Al}_2\text{O}_3$ (3.7)	$\alpha - \text{Al}_2\text{O}_3$ (2.4)	TiN (0.5)
	5 C	TiN (0.5)	I-TiCN (9.4)	TiN (0.6)	TiCN (3.6)	$\kappa - \text{Al}_2\text{O}_3$ (2.2)	TiN (0.4)
	6 D	TiN (0.9)	I-TiCN (8.5)	TiC (0.5)	TiCNO (0.3)	$\alpha - \text{Al}_2\text{O}_3$ (2.6)	—
	7 D	TiN (0.6)	I-TiCN (2.1)	TiC (2.7)	TiCNO (0.5)	$\alpha - \text{Al}_2\text{O}_3$ (1.4)	TiN (0.4)
	8 E	I-TiCN (6.6)	TiC (3.5)	Ti <sub>2</sub> O <sub>3</sub> (0.5)	$\kappa - \text{Al}_2\text{O}_3$ (3.2)	TiC (0.2)	TiN (0.3)
	9 E	TiC (1.0)	I-TiCN (12.0)	$\alpha - \text{Al}_2\text{O}_3$ (1.6)	TiCO (0.2)	TiN (0.4)	—
	10 F	TiC (1.2)	TiCNNO (0.7)	I-TiCN (14.5)	TiNO (0.5)	$\alpha - \text{Al}_2\text{O}_3$ (3.4)	$\kappa - \text{Al}_2\text{O}_3$ (2.9)

Table 6

Insert This invention	Flank wear (mm)		Insert Conventional	Flank wear (mm)	
	high speed and thick depth-of-cut	high speed and high feed		high speed and thick depth-of-cut	high speed and high feed
1	0.23	0.25	1	Failure at 1 min.	Failure at 1 min.
2	0.25	0.28	2	Failure at 1.5 min.	Failure at 2 min.
3	0.22	0.21	3	Failure at 2.5 min.	Failure at 2 min.
4	0.18	0.19	4	Failure at 3 min.	Failure at 2.5 min.
5	0.14	0.15	5	Failure at 3.5 min.	Failure at 3 min.
6	0.15	0.14	6	Failure at 3 min.	Failure at 3.5 min.
7	0.20	0.21	7	Failure at 1 min.	Failure at 1 min.
8	0.18	0.18	8	Failure at 2.5 min.	Failure at 3 min.
9	0.25	0.27	9	Failure at 2 min.	Failure at 1.5 min.
10	0.28	0.30	10	Failure at 0.5 min.	Failure at 1.5 min.

All failures were caused by chipping occurred at cutting edge

**Claims**

1. A coated cemented carbide cutting tool member comprising a substrate and a hard coating layer deposited on said substrate by chemical vapor deposition and/or physical vapor deposition,
  - 5 wherein said hard coating layer has average thickness of 3 to 25  $\mu\text{m}$ , and comprises (1) at least one Ti compounds layer that is composed of at least one granular layer of TiC, TiN, TiCN,  $\text{Ti}_2\text{O}_3$ , TiCO, TiNO and TiCNO, whose average thickness is 0.1 to 5  $\mu\text{m}$ , (2) TiCN layer having longitudinal growth crystal structure whose average thickness is 2 to 15  $\mu\text{m}$ , and (3)  $\text{Al}_2\text{O}_3$  layer whose average thickness is 0.5 to 8  $\mu\text{m}$ ,
  - 10 wherein, said longitudinal TiCN layer has compositional gradient of carbon and nitrogen along with its growth direction.
2. The coated cemented carbide cutting tool member according to claim 1, wherein the composition of said longitudinal TiCN layer is expressed as  $\text{TiC}_{1-x}\text{N}_x$ ,
  - 15 wherein, x value at top portion of said longitudinal TiCN layer is in the range of 0.45 to 0.95, and that value at bottom portion of said layer is in the range of 0.05 to 0.40.
3. The coated cemented carbide cutting tool member according to claims 1 and 2, wherein, compositional gradient in said longitudinal TiCN layer varies step-by-step.
- 20 4. The coated cemented carbide cutting tool member according to claims 1 and 2, wherein, compositional gradient in said longitudinal TiCN layer is continuous.
5. A process for producing a coated carbide member with longitudinal growth TiCN layer with compositional gradient, according to claim 1,2,3 and 4, the process comprising changing the reactive gas concentration of  $\text{CH}_3\text{CN}$ ,  $\text{CH}_4$ , and/or  $\text{N}_2$ , and the deposition temperature, from 850-950°C for the bottom portion to 960-1040°C for the top portion, during the deposition period of longitudinal TiCN layer.
- 25 6. The process according to claim 5, wherein the reactive gas concentration of  $\text{CH}_3\text{CN}$ ,  $\text{CH}_4$ , and/or  $\text{N}_2$ , and the deposition temperature are changed step by step during the deposition period of longitudinal TiCN layer.
- 30 7. The process according to claim 5, wherein the reactive gas concentration of  $\text{CH}_3\text{CN}$ ,  $\text{CH}_4$ , and/or  $\text{N}_2$ , and the deposition temperature are changed continuously during the deposition period of longitudinal TiCN layer

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## EUROPEAN SEARCH REPORT

Application Number  
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